

Work Order ID 73804

Thursday, September 15, 2011 3:28:23 PM



Page 1

Item ID: D2600-1-120

Accept



Setup Start



Revision ID:

Stop



Item Name: Extrusion Round 3" 206

Start Date: 9/15/2011 Start Qty: 150.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 150.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2600

Rev D1

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14904 ☐ a) Extrude as per Dwg D2600 ☐ b) Material: 6061-T6 (QQ-A-200/8) ☐ c) Minimum yield tensile strength = 35 ksi ☐ d) Minimum ultimate tensile strength = 40 ksi ☐ e) Minimum elongation = 8% ☐ f) Order at 160" long ☐ g) Bon L Canada Inc. tool #

11-09-15
(150)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

Rec'd 9/29 *(138)*

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester

- 5 miloz lbs (must be Bright 30AS) counted for spot inspect

(138) *[Signature]*

5 miloz/30

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/9/12 must Bring 30 pc to QC
for spot inspection

11/10/12 pour
OACQUER

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/12

11-10-03
13

Picklist Print

Thursday, September 15, 2011 3:28:20 PM

Page 1

Work Order ID: 73804



Parent Item: D2600-1-120



Parent Item Name: Extrusion Round 3" 206



Start Date: 9/15/2011

Required Date: 10/3/2011

Start Qty: 150.00

Required Qty: 150.00

Comments: IPP D: 02.09.05 Added DSK 066 KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-120P  Extrusion Round 3" 206		Purchased	No				Each	0.0000		150		9/15/25	138



DESIGN <i>DR</i>	DRAWN BY <i>DR</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. 0 SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01-04-17	ADD PART NUMBERS + DIE NUMBERS <i>40</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

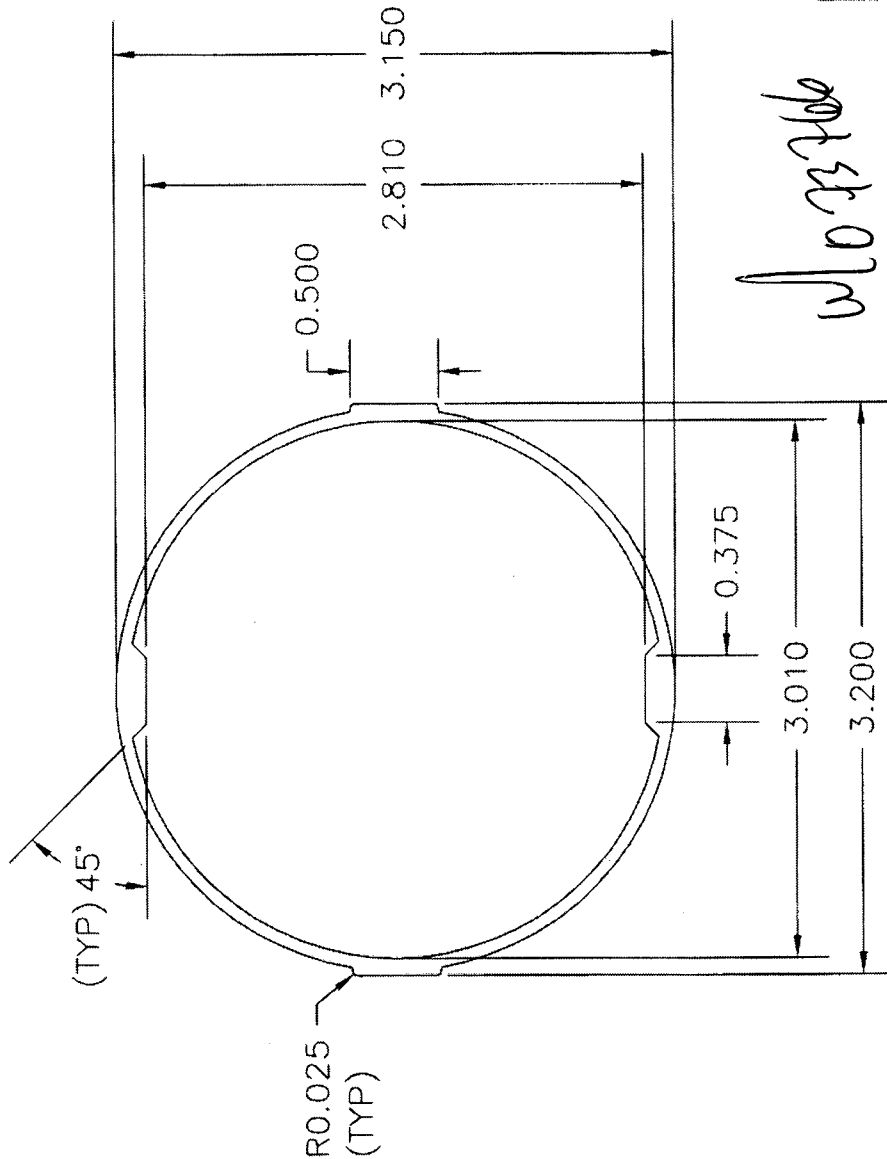
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

W/O 73806



DESIGN <i>DA</i>	DRAWN BY <i>DA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DA</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

OR BOW L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 16.00" LONG)

Δ_{DI}



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14904

Purchase Order Date 9/15/2011

PO Print Date 9/15/2011

Page Number 1 of 1

Order From : VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name		Buyer	Brigitte Golden
Vendor Phone	800 563 1079	Requisition Nbr	
Vendor Fax	800 565 8339	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	D2600-1-120P	Extrusion Round 3" 206	9/16/2011 Yes	150.00 Each	Yours ppd	\$30.6873	\$4,603.10
		Special Inst:	As per DWG: D2600 Rev: D1 B73804 Mat: 6061-T6 (QQ-A-200/8) Minimum yield tensile strength = 35 ksi, Min ultimate tensile strength=40 ksi, Min elongation=8% Order at 160" logn				
PO Total:							\$4,603.10

Change Nbr: 1

Change Date: 9/15/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

MANIFEST DATE / DATE DU BODEREAU 09-27-11
MANIFEST NUMBER / N° DE BODEREAU 002767
SALES ORDER NUMBER / N° DE COM 102812

SHIP TO / EXPÉDIÉ À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200	SOLD TO / VENDUE À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200
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TERMS / FREIGHT PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT 46024	ORDER DATE / DE LA COM 09/15/11	CUSTOMER PO NUMBER / CLIENT PO Nombre 14904	JOB / FICHIER	FIELD SALES REP / REP REGIONAL DES VENTES G.ATTENBOROU	SALES REP / REP. DES VENTES G.ATTENBOROU
BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 002767			CARRIER / TRANSPORTEUR JODEE	CUST SERVICE REP / REP. SERVICE CLIENTELE DLB	

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
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001	1,502	LB		DAA-897121-4	6061 T6		3	1,356	1,310	LB	
	681	KG			120.0000 IN			615	594	KG	
	150	PC			Cut(+): 0.0000 Cut(-): 0.0000	Min: 0 % Max: 0 %			138	PC	

						806452 / 118599	1	452	437		46 PC
						806452 / 118600	1	452	437		46 PC
						806452 / 118601	1	452	437		46 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

3	1,356	1,310	LB
	615	594	KG
		138	PC
TOTALS			

DRIVER

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
09/27/2011	5270169	102812	1
Cust PO	B/L No.	Lot	Date
14904	002767	806452	09/27/11

Sold To		Ship To	
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA		46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	
Item No	Part No.	Item Description	Cust Part
001	DAA-897121-4	120" MILL 6061 T6	
Gross Weight	1,356 LBS		
Net Qty	1,310 LBS		
Specification	AMS QQA 200/9 + ASTM B221-08		
	Die Desc.		

Mechanical Tests:

Tensile	Yield	% Elongation	Conductivity	HREW
MPA / KSI	MPA / KSI			
289.0 / 41.9	249.7 / 36.2	10.2	0.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.65	0.31	0.28	0.11	0.98	0.08	0.07	0.02	

u/09/29

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

R. Petersen, QA Manager Signature Aluminum Canada Inc